POTT-2 UNIT	Nylon Gel Spinning:				
8 40 40 1.16 1.16 1.16 2.9596 2.9596 0.2141 THRU-PUT PER FIL(GMS/MIN) 1.5982 2.2395 THRU-PUT(GMS/MIN) 1.5982 1.59964 3000 FROM FT/MIN TO M/MIN 0.3048 3000 FROM FT/MIN TO M/MIN 0.3048 4.79892 N/) 5.33213 0.02219 0.02219 0.032 0.093 3 0.0762 0.2286 3 0.0762 0.2286 3 0.0762 0.2286 3 0.0762 0.2286 3 0.0762 0.2286 3 0.0762 0.2286 3 0.0762 0.2286 3 0.0762 0.2286 3 0.0762 0.2286 3 0.0762 0.2286 3 0.0762 0.2286 3 0.0762 0.2286 3 0.0762 0.2286 3 0.0762 0.2286 3 0.0762 0.2286 3 0.0775 0.092 0.099 3 0.0776 0.092 0.099 3 0.0776 0.092 0.092 0.099 3 0.0776 0.092 0.092 0.099 3 0.0776 0.092 0.099 3 0.0776 0.092 0.099 3 0.0977 0.090	RXT-2 UNIT				
1.16	CHANGE NUMBERS WHERE IT IS BLUE COLOR				
1.16 1.16 1.16 1.16 1.19 1.19.7 0.98 2.95969 0.21141 THRU-PUT GER FIL (GMS/MIN) 22.395 1.59964 3000 FROM FT/MIN TO M/MIN 0.3048 4.79892 5.33213 22.1859 0.0762 0.0286 3 0.0762 0.0786 0.0886 3 0.0762 0.0786 0.0886 3 0.0776 0.0786 0.0886	MINIMUM PUMP RPM	8			
1.16 1.16 1.17 19.7 0.96 2.95969 0.21141 THRU-PUT PER FIL(GMS/MIN) 22.395 1.59964 3000 FROM FT/MIN TO M/MIN 1.5982 1.59964 3000 FROM FT/MIN TO M/MIN 0.00219 0.002219 0.002219 0.002219 0.002219 0.002219 0.002219 0.002219 0.002219 0.002219 0.002219 0.002219 0.002219 0.002219 0.002219 0.002210	MAXIMUM PUMP RPM	40			
14 19.7	PUMP SIZE(CC/REV.)	1.16			
19.7 0.96 2.95969 0.21141 THRU-PUT PER FIL(GMS/MIN) 1.59864 3000 FROM FT/MIN TO M/MIN 1.59964 3.3213 22.1859 0.02219 9842.52 diameter hength L/D 0.0228 5.33213 0.0228 5.13849 0.0762 0.0762 0.0025 0.0025 0.00055 0.00055 0.00075 0.00075 0.00075 0.00076 0.21141 61.1814 61.1814 61.2141 10 10 10 10 10 10 10 10 10 10 10 10 10	NUMBER OF FILAMENTS	14			
0.98 2.96969 2.29569 0.21141 THRU-PUT PER FIL(GMS/MIN) 1.5982 1.59964 TROW FT/MIN TO M/MIN 0.3048 3.000 FROM FT/MIN TO M/MIN 0.3048 4.79892 22.1859 22.1869 6.33213 0.09 3 9842.52 length L/D 0.03 0.09 3 0.0762 0.2286 3 67.1849 0.09 3 67.1849 0.00 1 60.1354 DR @ (TAKE-UP ROLL) 1 60.025 0.0075 1 0.0075 0.0075 1 0.2141 9.6E-07 1 34.343 8.5634 1 40 21.4101 1 10 0.47989 1	PUMP SPEED(RPM)	19.7			
2.95969 2.3669 0.21141 THRU-PUT PER FIL(GMS/MIN) 1.5982 1.59964 1.59964 22.395 3000 FROM FT/MIN TO M/MIN 0.3048 4.79892 22.1859 22.1869 6.33213 0.09 3 6.02219 0.09 3 9842.52 length UD dlameter length UD 0.03 0.09 3 67.1849 0.0762 0.2286 3 67.1849 0.0055 0.0075 0.0075 0.0075 0.0075 0.0076 0.0076 0.21141 8.6E-07 0.21141 0.21141 8.6E-07 34.3462 0.4389 0.47889	POLYMER DENSITY(GMCC)	0.98			
0.21141 THRU-PUT PER FIL(GMSMIN) 1.5982 1.59964 22.395 THRU-PUT(GMSMIN) 22.395 1.59964 3000 FROM FT/MIN TO M/MIN 0.3048 4.79892 22.1859 22.186 6.33213 22.1859 22.186 9842.52 length L/D dlameter length L/D 67.1849 0.0762 0.2286 3 67.1849 0.0762 0.2286 3 60.1354 0.0025 0.0025 0.0075 0.0075 0.0075 0.2141 0.21141 61.1814 8.6E-07 0.2141 0.2141 8.6E-07 34.345 0.24140 0.24140 10 21.4101 0.47989 0.47989	THRU-PUT(LBS/HR)	2.95969			
22.395 THRU-PUT(GMSMIN) 22.395 1.59964 3000 FROM FTAMIN TO MAMIN 0.3048 4.79892 6.33213 22.1859 0.02219 0.02219 0.033 0.093 3.00062 0.034 0.0762 0.07	THRU-PUT PER FIL(LBS/HR)	0.21141	THRU-PUT PER FIL(GMS/MIN)	1.5982	
1.59964 3000 FROM FTMIN TO MMIN 0.3048 4.79892 5.33213 5.33213 22.1859 0.02219 9842.52 Bength L/D 0.03 0.09 3 0.0762 0.2286 3 67.1849 67.1849 67.1849 60.1354 60.1354 60.1354 61.1814 8.6E-07 3143.9 6.56634 6.56634 70 21.4101 21.4101 6.47989	THRU-PUT(GMS/MiN)	22.395	THRU-PUT(GMS/MIN)	22.395	
3000 FROM FTMIN TO MMIN 0.3048 4.79892 22.1859 22.1865 22.1859 22.1859 22.1865 0.02219 22.1869 3 dlameter length L/D 0.03 0.09 3 67.1849 0.0026 3 50.1354 C.0025 22.852 50.1354 C.0025 20.0025 6.0.141 8.6E-07 21.410 8.6E-07 3143.9 8.6E-07 21.4101 21.4101 21.4101 0.47989 4.74989 2.74989	THRU-PUT PER FIL(GMS/MIN)	1.59964			
4.79892 5.33213 22.1859 0.02219 22.1866 0.02219 1.00 9842.52 0.09 3 0.0762 0.02286 3 67.1849 3 50.1354 DR @ (TAKE-UP ROLL) 0.0075 0.0075 0.0075 0.0075 61.1814 8.6E-07 0.21441 8.6E-07 3143.9 6.56634 10 21.4101 1.0 10 4.3462 1.0 10 0.47989 1.47989	TAKE-UP SPEED (Meter/min)	3000	FROM FTMIN TO MMIN	0.3048	
5.3213 22.1859 2.2.1859 22.1859 0.02219 1002219 dameter length 1/D 0.03 0.09 3 67.1849 0.02286 3 67.1849 22.852 1 5013.54 DR@ (TAKE-UP ROLL) 1 60.1354 0.0075 1 61.1814 1 1 61.1814 1 1 61.1814 1 1 61.1814 1 1 61.1814 1 1 61.1814 1 1 61.4101 1 1 21.4101 1 1 6.56534 1 1 70.4762 0.47989 1	DPF GMS @TAKE-UP ROLL (UNDRAWN)	4.79892			
22.1859 22.186 0.02219 22.186 9842.52 Inchests diameter 0.09 3 0.0762 0.2286 3 67.1849 3 5013.54 Inchests 1 5013.54 Inchests 1 5013.54 Inchests 1 61.1814 1 1 61.1814 1 1 86E-07 1 1 86.5634 1 1 10 21.4101 1 10 21.4101 1 10 21.4101 1 10 21.4101 1 10 21.4101 1 10 21.4101 1 10 21.4101 1	DTEX PER FIL GMS @TAKE-UP ROLL (UNDRAWN)	5.33213			
0.02219 9842.52	FIL DIAMETER, MICRONS (UNDRAWN)	22.1859		22.186	
9842.52 length L/D dlameter length L/D 0.03 0.09 3 (GMS) 67.1849 3 (GMS) 67.1849 3 5013.54 DR@ (TAKE-UP ROLL) 6 0.0075 0.0075 6 0.21141 61.1814 86E-07 61.56634 6.56634 10 dia. And fil dia.) 34.3462 10 DRAWNIN 10 64.7989 10	FIL DIAMETER, mm (UNDRAWN)	0.02219		_	
Spinnerette Bength UD	TAKE-UP SPEED (FEET/min)	9842.52		. 4	
OD 03 0.09 3 I DENIER @TAKE-UP ROLL (GMS) 67.1849 3 I DENIER @TAKE-UP ROLL (GMS) 67.1849 3 I PELOCITY (CMMIN) 5013.54 DR @ (TAKE-UP ROLL) FELOCITY (CMMIN) 50.1354 DR @ (TAKE-UP ROLL) 6 CAPILLARY RADIUS (FT) 0.0025 6 CAPILLARY LENGTH (FT) 0.0075 6 CAPILLARY LENGTH (FT) 0.21141 6 PUT PER FILLIBM/HR) 61.1814 6 N RATE(FT3/SEC.) 3143.9 65634 OSITY (LBI/SEC/FT2) 21.4101 21.4101 A PRESSURE(PSI) 21.4101 10 A PRESSURE(PSI) 34.3462 10 Oraw (calc: From sprt hole dia. And fil dia.) 10 Oraw (calc: From sprt hole dia. And fil dia.) 10 NING DRAW RATIO 0.47989	Spinnerette	diameter	hength	2	AREA
O.0762 O.2286 3	INCH	0.03	0.09	6	0.0007065
67.1849 22.852 5013.54 50.1354 DR @ (TAKE-UP ROLL) 0.0075 0.0075 0.21141 61.1814 8.6E-07 3143.9 6.56634 6.56634 10.0078	CM	0.0762	0.2286	6	0.00455806
22.852 5013.54 50.1354 DR @ (TAKE-UP ROLL) 0.0025 0.0075 0.21141 6.1814 8.6E-07 3143.9 6.56634 21.4101 34.3462	YARN DENIER @TAKE-UP ROLL (GMS)	67.1849			
50.1354 50.1354 DR @ (TAKE-UP ROLL) 0.0025 0.0075 0.21141 6.1.814 8.6E-07 3143.9 6.56634 21.4101 21.4101 0.47989	FLOW RATE(CC/MIN)	22.852			
50.1354 DR @ (TAKE-UP ROLL) 0.0025 0.0075 0.21141 61.1814 9.6E-07 3143.9 6.56634 21.4101 34.3462 0.47989	JET VELOCITY (CMMIN)	5013.54			
	JET VELOCITY (meter/MIN)	50.1354	DR @ (TAKE-UP ROLL)		59.8379407
	SPIN. CAPILLARY RADIUS (FT)	0.0025			
	SPIN. CAPILLARY LENGTH (FT)	0.0075	-		
	THRU-PUT PER FIL(LBm/HR)	0.21141			
	DENS/TY(LBm/FT3)	61.1814			
	FLOW RATE(FT3/SEC.)	9.6E-07			
	VISCOSITY (POISE)	3143.9			
	VISCOSITY (LBf.SEC/FT2)	6.56634			
	DELTA PRESSURE(PSI)	21.4101			
	Stack Draw (calc. From sprt hole dia. And fil dia.)	34.3462			
	FINAL REQUIRE DENIER AFTER DRAWIN	10			
	DRAWING DRAW RATIO	0.47989	1		

Semple LD.	Conditions	14	#	83	7	₹	2	*	**
				MBM 10%					
POLYMER TYPE	MBM	MBM .		Lactam	Lactam	Lactam	Lactam	Lactam	Lactam
Feeder Setting	2.96	2.96	2.96	2.96	2.96	2.96	2.96	2.96	2.96
	1	. 4				!			
water on feeding zone	8	vo	8	8	ક	æ	5	S	5
zone 1 Temp. (deg c)	245	270	250	250	245	240	236	230	22
zone 2 Temp. (deg c)	245	280	250	250	242	240	236	983	552
zone 3 Temp. (deg c)	245	280	250	250	248	240	235	988	226
zone 4 Temp. (deg c)	245	280	250	250	245	240	235	230	225
zone 5 Temp. (deg c)	245	280	250	250	245	240	235	230	725
zone 6 Temp. (deg c)	245	280	250	250	245	240	238	530	725
zone 7 Temp. (deg c)	245	280	250	250	245	250	236	730	225
8 Connecting Plate Temp. (deg. C)	245	280	250	250	245	240	238	230	225
9 Block Temp. (deg.C)	245	280	250	250	245	240	335	230	22
10 Spin Pump Temp. (deg.C)	245	280	250	250	245	240	235	230	225
11 Top Cap (deg.C)	245	280	250	250	245	240	235	230	225
12 Spin Pack Temp. (deg.C)	245	280	250	250	245	240	235	230	225
Top Heated Sleeve Length (Inches)	XXX	χοοχ	xxx						
Top Heated Sleeve Temp. (deg. c)	XXX	XXX	XXX	XXXX	XXX	XXX	XXX	xoox	: XX
Bottom Heated Sleeve Length (Inches)	XXX	хоох	χραχ	XXX	XXX	xxx	XXX	хоох	: XX
Bottom Heated Sleave Temp. (deg. c)	XXX	XXX	χοα	XXX	χοα	XXX	, XX	XXX	: XX
Barrel Melt Temp. (deg. c)	252	288	256	257	251	246	240	235	ឆ្ល
Melt Pump Inlet Preseure (psl)	ากก	420	10	200	10	01	10	2	 2
Melt Pump Outlet Pressure (psi)	nn	200	470	250	250	310	260	360	9
Extruder (rpm)	200	200	200	200	200	200	500	200	200
Spinnerst: no. of holes / Shape	14R	14 R							
Spinneret: capilary diameter & depth	.024 X 0.072								
Metering pump size (cc/rev)	1.16	1.16	1.16	1.16	1.16	1.16	1.16	1.16	1.16
Metering pump (rpm)	16.7	19.3	19.8	19.8	19.8	19.8	19.7	19.7	19.7
Thruput (lbs/hr/)	2.97	2.97	2.97	2.97	2.97	2.97	2.97	2.97	2.87
Filter type	STD SCREEN								
Monomer Exhaust Reading (inches water)		TBD	TBO	TBD	180	TBC			
Quench air Flow rate (CF/M)	14.2	14.2	14.2	14.2	14.2	14.2	15.5	15.9	14.9
Qench air Temp. (deg. c)	19	19	19	19	19	19	19.3	19.6	19.7
Quench air Humidity %	40.8	40.8	40.8	40.8	40.8	40.8	39.8	39.5	38
, % Torque	70	25	29	22	20	21	20	24	73
Nitrogen in Hoper	3	3	£	8	6	6	က	9	
Need: polymer chips moisture	, ¥88 ·							yas	
Mand . Para Life and Life A. Para ADDIT		~~~							::

Sample I.D.	2	0	5	212	200	*	2	#16	
		BHS 10%		135 10%					
POLYMER TYPE	. BH8	Lectern	Lactam	Lectern	Lactam	Lactem	Lactam	135	Lactam
Feeder Setting	2.96	2.96	2.96	2.96	2.98	2.96	2.96	2.96	2.96
water on feeding zone	ક	8	ક	S	8	uo	8	8	5
zone 1 Temp. (deg c)	252	252	247	242	237	232	227	280	260
zone Z Temp. (deg c)	252	252	247	242	237	232	227	280	780
zone 3 Temp. (deg c)	252	252	247	242	723	232	227	280	260
zone 4 Temp. (deg c)	252	252	247	242	237	232	227	260	5 60
zone 5. Temp, (deg c)	385	- 253	247	2#3	237	22	122	280	280
zone 6 Temp. (deg c)	252	282	247	242	237	232	122	5 80	8
zone 7 Temp. (deg c)	252	252	247	242	237	232	722	260	5 80
8 Connecting Plate Temp. (deg. C)	252	252	247	242	237	232	227	260	92 28
9 Block Temp. (deg.C)	252	252	247	242	237	232	222	260	280
10 Spin Pump Temp. (deg.C)	252	252	247	242	237	232	227	260	98
11 Top Cap (deg.C)	252	252	247	242	182	232	227	260	260
12 Spin Pack Temp. (deg.C)	252	252	247	242	237	232	227	280	5 80
Top Heated Sleeve Length (Inches)	XX	XXX	XXX	xxx	XXX	XXX	XXX	χοοα	XX
Top Heated Sleeve Temp. (deg. c)	хоох	XXX	хоох	χοα	XXX	XXX	хосох	XXX	
Bottom Heated Steeve Length (Inches)	XXX	XXX	XXX	xxx	XXX	XXXX	XXX	X	
Bottom Heated Sleeve Temp. (deg. c)	XXX	2000	хоох	xxx	XXXX	XXXX	xxx	XXX	
Barrel Melt Temp. (deg. c)	259	560	254	249	245	240	235	270	
Malt Pump Iniet Pressure (psl)	\$	8	250	280	180	50	2	1200	
Meit Pump Outlet Pressure (pst)	970	520	570	610	740	790	8	1600	
Extruder (rpm)	200	200	200	200	200	200	200	200	
Spinneret: no. of holes / Shape	14 R	14 R	14 R	14R	14 R	14 R	4. R.	14 R	
Spinnenet: capilary diameter & depth	.024 X 0.072	024 X 0.072	О.						
Metering pump size (cc/rev)	1.16	1.18	1.15	1.16	1.16	1.16	1.10	1.16	
Metering pump (rpm)	19.7	19.7	19.7	19.7	19.7		19.7	19.7	19.7
Thruput (ibs/hr)	2.97	2.97	2.97	2.97	2.97	2.97	2.97	2.97	2.97
Filter type	STD SCREEN	STD SCREE	STD SCREEN	STD SCREEN	STD SCREEN				
Monomer Exhaust Reading (inches water)	TBO	T80	TBD	TBO	ТВО	TRO	37-		· · · · · · · · · · · · · · · · · · ·
Quench air Flow rate (CF/M)	14.6	14.5	14.6	14.9	15	14.6	6,4		15.1
Qench air Temp. (deg. c)	18.5	16.9	19.2	19.2	18.7	19	19.4	18.5	18.2
Quench air Humidity %	38.7	39.3	39.7	41.6	39.7	40.3	39.4	38.6	41.1
% Torque	42	27	82	ရှ	8	ຊ:	53	\$	37
Nitrogen in Hoper	3	3	8	3	3	6	က	m :	m
Need: polymer chips moisture									:
Need: Free fall samples for FAV, COOH								1-	
							_		

	136 10% Lactem	135 10% Lactern	4.96 4.08. 3 arrhorn	135 10%	135 10%	135 10%	135 10%		195 10%
			436 400K 5 actors	-					
Feeder Setting water on feeding zone	ı		I SO ION PERMIT	- FEEDW	Lectam	Lactam	Lactam	195	Lactam
water on feeding zone	2.96	2.96	2.96	2.98	2.98	2.96	2.96	2.96	2.96
water on feeding zone	4. S. reference	482	. 43			Ç.	t,		ا إ. إ.
Arms famous 110 terms	8	8	8	8	£	8	8	6	CO
	26.6	35	246	240	235	230	225	300/289	280/273
Compared Towns	25.5	250	245	240	235	230	225	300	8
(a fight delite)	266	250	245	240	235	230	225	န္တ	290
	1	250	245	240	235	230	225	300	580
work + tenpo (con con	200	250	246	240	735	230	228	360	530
Zone o Temps (deg C)	286	250	245	240	235	230	225	S	290
Total Term (des e)	248	250	245	240	235	230	225	300	290
Commenter Dieta Team (Ann C)	265	250	285	240	235	230	225	ဓ္က	290
o considering have ready (way- c)	255	250	245	240	236	230	225	300	290
10 Sain Dimo Tomo (dea C)	25.6	250	245	240	235	230	226	300	290
44 Too Can (dea C)	355	250	245	240	235	230	226	300	230
43 Only Town (doc ?)	785	250	245	240	235	230	225	300/300	280
The Heated Glacus (court (Inches)	2000	XXX	XXX	XX	XXX	XXX	XXX	XXX	XX
Ton Masted Cleans Terms (dan c)	200	XXX	2000	XXX	XXX	XXX	XXXX	XXX	XXX
Rottom Masted Steam enough Onches!	2000	XXX	XXX	XXX	XXX	XXX	XXXX	XXX	XXX
Bottom Heated Steeve Temp (den c)	XXX	XXX	XXX	XXX	XXX	XXX	XXX	XXX	XXX
Barrel Melt Temp (dag c)	284	259	253	248	243	238	232	312	533
Mek Pum injet Pressure (rel)	630	470	450	630	800	280	190	8	1080
Mak Dimo O. Hat Drass res (nel)	1080	1140	1280	1280	1330	1480	1700	1280	280
Extruder (con)	2002	200	200	200	200	8	200	8:	8.
Solonerst: no. of holes / Shape	14 R	14 R	14.R	14 R	14 R	7. R	7 2	14 R	7 4
£	024 X 0.072	.024 X 0.072	.024 X 0.072	.024 X 0.072	.024 X 0.072	.024 X 0.072	.024 X 0.072	.024 × 0.072	024 X 0.072
\vdash		1.16	1.18	1.16	1.16	1.18	1.18	+	- i -
Metering pump (ram)	19.7	19.7	19.7	19.7	19.7	19.7	19.7	19.0	200
Throat (bs/hr)	2.87	2.97	2.97	2.97	2.97	2.97	2.97	/A'7	ישמעיה עדם
	STD SCREEN	STD SCREEN	STD SCREEN	STD SCREEN	STD SCREEN	STD SCREEN	S I D SCREE	NOTE STREET	200
d (inches water)	TBO	ΩÐL	TBD	TBO	TBO	35		44.6	14.8
Ovench air Flow rate (CF/M)	15.2	14.9	14.5	14.4	14.9	4	7.4.5	2 0	: 'u
Oench air Temo. (deg. c)	20.1	19.5	18.7	18	18.9	19.1	18/	n 9	2
Ovench air Humidity %	39.4	40.7	39.7	40.1	41.3	28		315	3
% Toraue	39	38	\$	37	23	3 4	7 -	, ~	. e
Nitrogen in Hoper	3	3	3	6	m	n!	٠ -	,	· •
Need : polymer chips moisture									:
Need : Free fall samples for FAV, COOM							! ! ! ! ! ! ! ! ! ! ! ! ! ! ! ! ! ! !	-	:

195 10% Lactam 195 10% Lactam 2.96 2.96 2.96 2.96 2.96 2.96 2.96 2.96 2.96 0n 0n 0n 200, 286 2.75,2583 285 280 275 285 280 275 285 280 275 285 280 275 285 280 275 285 280 275 285 280 275 285 280 275 285 280 275 285 280 275 285 280 275 285 280 275 285 280 275 286 880 890 870 280 280 860 860 880 880 890 870 280 297 2.97 2.97 281 43.1 43.1	Sample LD.	154	-		
195 10% Lactam Lactam 196 10% Lactam 2.96 2.96 2.96 2.96 2.96 2.96 2.96 2.96 2.96 2.96 2.96 2.96 2.97 2.90 275 2.96 2.85 2.80 275 275 2.85 2.80 2.75 2.75 2.85 2.80 2.75 2.75 2.85 2.80 2.75 2.75 2.85 2.80 2.75 2.75 2.85 2.80 2.75 2.75 2.85 2.80 2.75 2.75 2.85 2.80 2.75 2.75 2.85 2.80 2.75 2.75 2.85 2.80 2.75 2.84 2.86 2.89 2.84 2.84 2.80 2.89 2.84 2.84 2.80 2.80 2.97 2.97 2.87 2.97 2.97 2.97			195 10%		195 10%
2.96 2.96 2.96 5	POLYMER TYPE	195 10% Lectern	Lactam	196 10% Lactem	Lactern
con on on con con con	Feeder Setting	2.96	2.96	2.96	2.96
on on on 286/270 280/286 275/263 285 280 275 285 280 275 285 280 275 285 280 275 285 280 275 285 280 275 285 280 275 285 280 275 285 280 275 285 280 275 285 280 275 285 280 275 285 280 275 285 280 275 286 289 280 286 289 280 14 R 14 R 14 R 14 B 14 R 14 R 14 B 14 R 14 R 19.7 19.7 19.7 297 2.97 2.97 297 43.1 43.1 41.7 2.8 <td></td> <td>1 N</td> <td>· 150</td> <td></td> <td>4 4 40 1</td>		1 N	· 150		4 4 40 1
265/270 260/286 275/263 285 280 275 285 280 275 285 280 275 285 280 275 285 280 275 285 280 275 285 280 275 285 280 275 285 280 275 285 280 275 285 280 275 285 280 275 285 280 275 285 280 284 286 289 284 1250 50 80 860 890 970 860 890 970 860 890 970 14 R 14 R 14 R 19.7 19.7 19.7 19.7 19.7 19.7 19.7 14.7 14.2 19.7 29	water on feeding zone	g	uo	6	5
285 280 275 285 280 275 285 280 275 285 280 275 285 280 275 285 280 275 285 280 275 285 280 275 285 280 275 285 280 275 285 280 275 285 280 275 285 280 284 286 289 284 1250 50 860 860 890 970 860 890 970 860 890 970 14 R 14 R 14 R 157 19.7 19.7 19.7 19.7 19.7 19.7 19.7 14.2 14.7 14.2 43.1 41.3 3 3 3 3 3 <td>zone 1 Temp. (deg c)</td> <td>265/270</td> <td>280/288</td> <td>275/283</td> <td>952/0/2</td>	zone 1 Temp. (deg c)	265/270	280/288	275/283	952/0/2
285 280 275 285 280 275 285 280 275 285 280 275 285 280 275 285 280 275 285 280 275 285 280 275 285 280 275 285 280 275 285 280 275 285 280 275 285 280 275 286 280 275 286 280 80 280 200 80 200 200 200 480 480 87 14 R 14 R 14 R 14 B 1.16 1.16 15 T 19.7 19.7 18 T 2.97 2.97 28 T 37 41.7 2.8 37 41.7 2.8 3 <t< td=""><td>zone 2 Temp. (deg c)</td><td>285</td><td>280</td><td>275</td><td>22</td></t<>	zone 2 Temp. (deg c)	285	280	275	22
285 280 275 285 280 275 285 280 275 285 280 275 285 280 275 285 280 275 285 280 275 285 280 275 285 280 275 285 280 275 286 280 275 286 289 284 1250 50 860 860 890 870 14 R 14 R 14 R 14 B 14 R 14 R 14 C 18 T 18 T 29 T 29 T 46 I 41 S 3<	zone 3 Temp. (deg č)	582	280	275	22
285 280 275 285 280 275 285 280 275 285 280 275 285 280 275 285 280 275 285 280 275 285 280 275 285 280 275 285 280 275 286 289 284 1250 60 860 860 890 970 200 200 200 14 R 14 R 14 R 14 B 1.16 1.16 1.16 1.16 1.16 1.18 1.19 1.16 1.19 1.17 14.7 29T 2.97 2.97 29T 2.97 2.97 29T 44.1 44.1 46.1 41.7 44.2 46.1 41.3 3 3 3	zone 4 Temp. (deg c)	285	280	275	270
285 290 275 286 280 275 285 280 275 285 280 275 285 280 275 285 280 275 285 280 275 285 280 275 285 280 275 285 280 275 280 284 284 1250 50 860 860 890 970 200 200 200 14R 14R 14R 118 1.16 1.16 19.7 19.7 19.7 19.7 19.7 19.7 29T 2.97 2.97 29T 2.97 2.97 29T 44.7 14.2 46.1 41.3 43.1 46.1 41.3 3 3 3 3	zone 5 Temp. (deg c)	285	280	275	270
285 280 275 285 280 275 285 280 275 285 280 275 285 280 275 285 280 275 285 280 275 285 280 275 286 289 284 1250 50 860 860 890 370 200 200 200 14 R 14 R 14 R 14 R 19.7 19.7 19.7 2.97 2.	zone 6 Temp. (deg c)	285	280	275	270
285 280 275 285 280 275 285 280 275 285 280 275 285 280 275 285 280 275 280 275 275 280 280 284 1250 50 860 860 890 370 201 202 200 14R 14R 14R 14R 14R 14R 14R 14R 14R 19.7 19.7 19.7 19.7 19.7 19.7 19.7 19.7 19.7 2.97 2.97 2.97 2.97 2.97 2.97 2.97 2.97 2.97 2.97 2.97 2.97 2.97 2.97 2.97 4.1.7 14.7 14.2 14.7 14.2 14.2 46.1 4	zone 7 Temp. (deg c)	285	280	275	270
285 280 275 285 280 275 285 280 275 285 280 275 280 275 275 280 275 275 280 275 275 280 275 275 280 275 284 280 289 284 280 289 970 200 200 200 14R 14R 14R 116 1.16 1.16 118 1.16 1.16 19.7 19.7 19.7 19.7 19.7 19.7 19.7 19.7 19.7 11.6 1.16 1.16 11.7 14.7 14.2 11.7 14.7 14.2 11.7 14.7 14.2 11.7 20 46.1 46.1 28 37 3 3	8 Connecting Plate Temp. (deg. C)	285	280	275	270
285 280 275 285 280 275 285 280 275 285 280 275 286 280 275 280 289 284 296 289 284 296 289 284 296 289 870 860 890 970 200 200 200 204 207 200 200 204 207 200 20 200 200 204 207 207 208 850 890 850 890 870 207 207 207 1.16 1.16 1.16 1.16 1.16 1.16 1.18 1.16 1.18 1.16 1.16 1.19.7 19.7 19.7 19.7 19.7 19.7 19.7 14.7 14.2 19.2 18.7 20 20 0pen 20 0pen 20 0pen 20 18.7 2.97 2.97 2.97 2.97 2.97 2.97 2.97 2.97	9 Block Temp. (deg.C)	285	280	275	270
285 280 275 285 280 276 286 280 276 280 200 200 280 289 284 286 289 284 298 289 284 298 289 284 298 289 284 298 289 284 298 289 284 298 289 284 298 289 284 298 289 284 298 289 284 298 289 284 298 289 284 200 200 200 200 200 200 201 18 14 R 14 R 202 202 203 203 200 200 204 X 0.072 .024 X 0.072 1.16 1.16 1.16 19.7 19.7 19.7 19.7 2.97 2.	10 Spin Pump Temp. (deg.C)	285	280	275	270
285 280 275 xxxx xxxx xxxx 286 289 284 287 289 284 280 289 284 280 280 370 200 200 200 200 200 200 1.16 1.16 1.16 1.15 1.16 1.16 1.16 1.16 1.16 1.17 1.16 1.16 1.18 1.16 1.16 1.17 1.17 1.15 1.18 1.16 1.16 2.97 2.97 2.97 2.97 2.97 2.97 3 3.7 43.1 41.3 41.3 43.1 41 28 37 3	11 Top Cap (deg.C)	285	280	275	270
XXXX XXXX XXXX XXXX XXXX XXXX XXXX XXXX XXXX XXXX XXXX XXXX Z86 289 284 284 1250 50 860 860 860 890 970 200 200 200 200 200 14 R 14 R 14 R 16 T 118 1.16 1.16 17 B 1.18 1.16 1.16 19.7 19.7 19.7 19.7 19.7 19.7 19.7 14.2 14.7 14.7 14.2 19.2 18.7 2.97 20pen apen apen apen 46.1 46.1 43.1 41.3 28 37 3 3 3 3 3 3	12 Spin Pack Temp. (deg.C)	285	280	275	270
xxxx xxxx xxxx xxxx xxxx xxxx 286 289 284 286 289 284 1250 60 860 860 890 970 200 200 200 200 200 200 14 R 14 R 14 R 14 R 14 R 14 R 14 R 14 R 14 R 16 T 19 T 19 T 18 T 19 T 19 T 18 T 14 T 14 T 18 T 18 T 20 46 T 41 T 28 37 3 3 3 3	Top Heated Sieeve Length (Inches)	XXX	XXX	XXX	XXX
xxxx xxxx <th< td=""><td>Top Heated Steeve Temp. (deg. c)</td><td>XXX</td><td>XXX</td><td>хоох</td><td>XXX</td></th<>	Top Heated Steeve Temp. (deg. c)	XXX	XXX	хоох	XXX
χοα χοα χοα 296 289 284 1250 50 860 860 890 970 200 200 200 201 200 200 202 200 200 14 R 14 R 14 R 1024 X 0.072 .024 X 0.072 .024 X 0.072 1.16 1.16 1.16 1.16 1.16 1.16 1.17 19.7 19.7 19.7 19.7 19.7 2.97 2.97 2.97 2.97 3.0 SCREEN STD SCREEN 14.7 14.2 14.7 14.2 14.7 14.2 46.1 41.5 43.1 41.3 28 37 3 3 3 3 3 3	Bottom Heated Sleeve Length (Inches)	XXX	XXX	XXX	XXX
296 289 284 1250 60 860 860 890 970 200 200 200 200 200 200 204 200 200 204 200 200 204 200 200 204 207 204 2072 1.16 1.16 1.16 19.7 19.7 19.7 2.97 2.97 5.10 SCREEN STD SCREEN 0pen open open 14.7 14.2 19.2 18.7 2.0 46.1 41.5 43.1 41.5 28 37 3 3 3	Bottom Heated Sleeve Temp. (deg. c)	XXX	XXX	XXX	1000
1250 50 860 860 890 970 200 200 200 200 200 200 200 201 14 R 14 R 14 R 14 R 14 R 14 R 16 R 116 116 118 116 116 19.7 19.7 19.7 2.97 2.97 2.97 2.97 2.97 2.97 2.97 2.97 2.97 2.97 2.97 2.97 2.97 2.97 3. 3. 3. 3. 3.	Barrel Melt Temp. (deg. c)	288	289	284	279
860 890 970 200 200 200 200 200 200 201 14 R 14 R 14 R 0.024 X 0.072 .024 X 0.072 1.16 1.16 1.16 1.16 1.16 1.16 1.17 19.7 19.7 2.97 2.97 2.97 2.97 2.97 2.97 2.97 2.97 2.97 2.97 2.97 2.97 2.97 2.97 2.97 2.97 2.97 2.97 3.1 41.5 43.1 46.1 41.5 43.1 3 3 3	Melt Pump Inlet Pressure (psl)	1250	90	098	1060
200 200 200 200 14 R 14	Melt Pump Outlet Pressure (psl)	88	890	026	1100
14 R 14 R 14 R 14 R 14 R 14 R	Extruder (rpm)	200	200	200	500
.024 X 0.072 X	Spinneret: no. of holes / Shape	14R	14 R	14 R	14 R
1.16 1.16 1.16 1.16 1.16 1.16 1.16 1.15 19.7 19.7 2.97	Spinneret: capitary diameter & depth	.024 X 0.072	.024 X 0.072	.024 X 0.072	.024 X 0.072
19.7 19.7 18.7 2.97 2.97 2.97 STD SCREEN STD SCREEN Open open open open 14.7 14.2 19.2 18.7 2.0 46.1 41.5 43.1 41. 28 37 3 3 3	Metering pump size (cc/rev)	1.18	1.18	1.16	1.16
2.97 2.97 2.97 2.97 2.97 SCREEN STD SCREEN OPEN OPEN OPEN OPEN OPEN OPEN OPEN O	Metering pump (rpm)	19.7	19.7	18.7	19.7
STD SCREEN STD SCREEN STD SCREEN open open open 14.7 14.7 14.2 19.2 18.7 20 46.1 41.5 43.1 41 28 37 3 3 3	Thruput (ibs/hr)	2.97	2.97	2.97	2.97
open open open 14.7 14.2 14.2 19.2 19.7 20 46.1 41.5 43.1 41 28 37 3 3 3	Filter type	STD SCREEN	STD SCREEN	STD SCREEN	STD SCREE
14.7 14.7 14.2 19.2 18.7 20 46.1 41.5 43.1 41 28 37 3 3 3	Monomer Exhaust Reading (Inches water)	uado	uedo	uado	uado
19.2 18.7 2.0 46.1 41.5 43.1 41 28 37 3 3 3	Quench air Flow rate (CF/M)	14.7	14.7	14.2	13.9
46.1 41.5 43.1 41 28 37 3 3 3	Qench air Temp. (dog. c)	19.2	18.7	20	18.7
41 28 37 3 3 3	Quench air Humidity %	46.1	41.5	43.1	39.4
3 3	% Torque	41	28	28	14
	Nitrogen in Hoper	6	3	£	e

•																																															•	
7-50	12.5 %MBM	77.5% Technic +	Blend 7	260215		5	15.04 10.04	o 6	3901	3801	}		ti	4291	3901	9		ø	F122141038	5	215	215	215	215	218	210	210	213	213	2 4	218	217	089	430	220		12 R ,	0.0177 x 0.061	1.16	9 2	60	STD SCREEN	Z :	19.1	40.3	.	e	484
27-25	12.5.%MBM	77.5% Technic • 10% Lectern	Blend 7	£1672.303		8	F-137	m	5.16 500	3901	- 065			4291	3901	52	١	4	S. '4- 3	5	215	215	215	215	215	210	210	213	213	217	218	217	400	210	520			190	1.18	9.5		Z	6.8	18.9	41.2	₽ .	m	8
6-50	5 %MBM	17.5% Technic +	Blend 6	ن ښت		45	F-137	9:0	3.28	2000	290			4174	3901	8		•	;	5	215	215	215	215	215	210	210	213	213	2.5	218	217	1040	68	220		12 R	0.0177 x 0.081	1.18	8	en	STD SCREEN	6.7	19.7	38.9	8	m	œ
6-25	5 XMBM	77.5% Technic •	Blend 6	1	2.27.40	45	F-137	m	5.16	3901	LOAS	٠		4291	3901	52		1.5	£ 7.	3	215	215	215	215	215	210	210	213	213	2 4	21.5	217	1100	8	220		12 R	0.0177 x 0.061	1.16	8.5	1.5	STD SCREEN	6.9	19.1	40.2	5 9	6	÷
5-50	12.5 %MBM	70% Technic +	Riond 5			45	F-137	3.5	3.28	3901	3901			4291	2001	8		m	**************************************	8	215	215	215	215	215	210	210	213	213	946	218	217	750	120	520			0.017	1.16	18	6	STD SCREEN	6.9	18.5	39.7	17	m	ç
5-25	MOLLY R.C.	70% Technic +	17.5% Lactern	و المالية		45	F-137	Ю	5.16	3680	3680			4334	955	22 12	_	1.6	í å,	8	215	215	215	215	215	210	210	213	213	515	218	217	610	8	220		12 R	0.0177 x 0.061 0.0177 x 0.061 0.0177 x 0.061	1.18	9.5		STDS	6.8	20.1	43.1	6	m	3
4-50			=	Blend 4		ĄŁ	F-137	6	3.28	3680	3680		_	*****	4331	\$.c.	}	es		8	215	215	215	215	215	210	210	213	213	612	218	217	870	250	220		12 R	31 0.0177 x 0.06	1.16	8 2 .		STO	Σ.	18.9	4	8	e	æ
4-25	I		- 2	Blend 4		4	F. 427		5.16	3680	3680				2	3 ×	}	5.1		8	215	215	215	215	215	210	210	213	213	612	218	217	360	8	220				1.16	9.5		STS	6.9	19.5	40.4	7	6	÷
3-50	ļ		-	Blend 3	•		10.4	<u> </u>	3.28	3680	3680			-	4331	2	3 [.]	en	,	5	215	215	215	215	215	210	210	213	213	613	2.5	212	1040	20	220		12 R	81 0.0177 x 0.061	1.16	82		STDS	6.9	18.7	38.2	91	6	-
3-25		5 NABM TO% Technic	==	Blend 3			200	2	91.9	3680	3680	: 	-		4331	4 8 7	Í	1.5		8	215	215	215	215	215	210	210	213	233	613	2 2	217	700	0	8		12 R	0.0177 x 0.061 0.0177 x 0.061 0.0177 x 0.061 0.0177 x 0.061	1.16	9.5		N STD SCREEN	7.7	19.1	41.8	5	m	4
2-50	1	5%MBM + 85% Technic +	-	Blend 2		•	1 4 5		3.28	3680	3680		*1	•		3 .5	3	· 103		.	216	215	215	215	215	210	210	213	213	612	2. 8.5	218	480	440	220		12 R	31 0.0177 × 0.04	1.16	. 4		STO	7.3	20.3	43.1	27	e	•
2.25		20 KMBM 5KMBM	10% Ladam		3		54	F-13/	2 t	3680	3680				4210	8	ç, —	1.6	1,40,40,0	8	215	215	215	215	215	210	210	213	213	21.7 2.6	C 45	218	350	6	220		12 R	11 0.0177 x 0.06	1.16	9.5	1.5	STDS	6.8	18.5	42.7	4	6	c
4	00-1	Sec. 1. 1	4 1 1 2				45	F-137	9	35.00	9680	3	,	ı.	7 4372	4048 8404	<u>S</u>	6	1	5	215	215	215	215	215	210	210	213	213	212 1	CE 2	218	1490	490	220		12 R		1.16	18		STD SCREEN	7.6	19.8	40.1	æ		
40.1	J	20 KMBM						ŭ.		3680					4453		7 2	1.5		5	216	215	212		215	210	210	_			61.						9 12R	0.0177 x 0.061		9.5	1.5	Filter type STD SCREEN		19.6	•			;
	Semple I.D.		POLYMER TYPE	Polymer Type/Blend ID:	SAMPLE START TIME	SAMPLE FINISH TIME	Run time (min)	Finish type	Kiss roll (rpm)	SCOAM	7-174 (minim) page 1 # noa 7 PAT-1		let type	air to jet (pai)	Winder grove roll: Speed (m/rhin.)	Winder drive roll: Speed (mymin.	(in Undrawn.Denier	Feeder Setting		water on feeding zone	zone 1 Temp. (deg c)	zone 2 Temp. (deg c)	zone 3 Temp. (deg c)	zone 4 Temp. (deg c)	zone 5 Temp. (deg c)	zone 6 Temp. (deg c)	zone 7 Temp. (deg c)	Connecting Plate Temp. (deg. C)	Block Temp. (deg.C)	Spin Pump Temp. (deg.C)	1 op Cap (deg.c)	Spill Fack Temp. (deg. c)	Melt Pump Inlet Pressure (psi)	Melt Pump Outlet Pressure (psi)	Extruder (rpm)	Monomer Exhaust inches water	Spinneret: no. of holes / Shape	Spinneret: capilary diameter & depth	Metering pump size (cc/rev)	Metering pump (rpm)	Thruput (lbs/hr)	Filter type	Quench air Flow rate (CF/M)	Qench air Temp. (deg. c)	Quench air Humidity %	% Torque	Nitrogen in Hopper	

17. Chairs 17. Chair	300	Rate (C/mi	Rate (C/min):	20	Hold	Hold (min):	
(C) (J/g) onset (C) (J/g) (J/g) (C) (J/g) <			Melting Po	aks			Total
(G) (Jg) onset (C) (Jg) onset (C) (Jg)	Onset	1st Tm	1st Area	1st Tm-	2nd Tm	2nd Area	ΔHf
176.7 52.6 17.2 213.1 18.5 178.8 54.0 13.2 214.5 17.5 177.8 53.3 15.2 213.8 18.0 177.4 56.6 10.5 209.2 4.7 170.1 52.1 10.5 208.9 3.8 162.0 65.8 26.1 208.2 202.9 4.2 162.0 65.8 26.1 202.0 212.9 4.2 162.0 65.8 26.1 202.0 212.9 4.2 162.0 65.8 26.1 202.0 212.9 4.2 163.7 20.0 212.9 4.2 4.1 176.1 55.0 20.0 212.9 4.7 177.2 55.1 10.0 212.9 4.7 168.3 64.1 21.6 20.0 4.1 169.2 71.9 26.3 16.7 20.0 4.1 169.2 71.9 26.3 16.7		(၁)	(6/C)	onset	(c)	(3/g)	(6/C)
178.8 54.0 13.2 214.5 17.5 177.8 53.3 15.2 213.8 18.0 177.4 56.6 10.5 209.2 4.7 170.1 47.6 10.4 208.9 2.3 177.3 52.1 10.5 208.9 3.8 162.4 65.0 28.2 20.2 3.9 162.0 65.8 25.1 202.0 212.9 4.2 162.0 65.8 25.1 20.0 212.9 4.2 163.1 55.0 20.0 212.9 9.5 176.1 55.0 20.0 212.9 4.7 176.2 55.1 19.0 212.9 4.7 177.2 55.1 19.0 212.9 4.7 168.3 64.1 21.6 209.0 4.1 168.3 64.1 21.6 209.0 4.1 168.3 64.1 21.6 209.0 4.1 168.3 16.7	159.5	176.7	52.6	17.2	213.1	18.5	71.1
177.8 53.3 15.2 213.8 18.0 172.4 56.6 10.5 209.2 4.7 170.1 47.6 10.4 208.5 2.9 177.3 52.1 10.5 208.9 3.7 162.0 65.8 28.2 202.3 3.7 162.0 65.8 25.7 202.9 4.2 162.0 65.8 25.7 202.9 3.9 176.1 53.1 20.0 212.9 9.5 177.9 55.0 20.0 212.9 9.5 174.9 55.1 19.0 212.9 19.7 175.2 55.1 19.0 21.9 4.1 177.2 43.0 11.6 213.9 17.2 168.3 64.1 21.6 209.0 4.1 168.4 21.9 21.0 17.2 177.1 46.2 11.8 21.2 4.4 177.0 49.5 11.6 21.0 17.2<	165.6	178.8	54.0	13.2	214.5	17.5	71.4
172.4 56.6 10.5 209.2 4.7 170.1 47.6 10.4 208.5 2.9 170.1 47.6 10.4 208.5 2.9 162.0 65.0 28.2 202.3 3.7 162.0 65.8 25.1 202.9 3.9 162.0 65.8 25.1 20.0 212.9 9.5 176.1 57.0 20.0 212.9 9.5 174.0 55.0 20.0 212.9 9.5 174.0 55.1 19.0 21.9 17.0 175.2 55.1 19.0 21.9 17.0 177.2 43.0 11.6 213.9 17.2 168.3 64.1 21.6 205.7 4.4 168.3 64.1 21.6 205.7 4.4 177.2 43.0 11.6 213.9 18.5 177.1 46.2 11.8 217.4 4.4 177.2 43.0 11.6	162.6	177.8	53.3	15.2	213.8	18.0	71.3
170.1 47.6 10.4 208.5 2.9 171.3 52.1 10.5 208.9 3.8 165.4 65.0 28.2 202.3 3.7 162.0 65.8 25.1 202.9 3.9 162.0 65.8 25.1 202.9 3.9 176.1 53.1 20.0 210.8 12.6 177.9 55.0 20.0 213.4 19.7 175.5 55.1 19.0 213.4 19.7 176.4 55.0 20.0 210.8 12.6 177.2 56.1 19.0 213.4 19.7 160.7 56.1 17.2 17.2 17.2 168.3 64.1 21.6 207.4 4.4 168.3 64.1 21.6 207.4 4.4 177.0 49.5 11.9 213.9 18.5 177.1 46.2 11.8 217.4 4.4 177.0 49.5 11.9	161.9	172.4	9.95	10.5	209.2	4.7	61.2
171.3 52.1 10.5 208.9 3.8 165.4 65.0 28.2 202.3 3.7 165.4 65.0 28.2 202.3 3.7 162.0 65.4 26.1 202.9 4.2 176.1 65.0 20.0 212.9 4.2 176.1 65.0 20.0 213.9 1.0 176.2 55.1 19.0 213.4 19.7 176.2 55.1 19.0 213.4 19.7 176.2 55.1 19.0 213.4 19.7 177.2 56.3 16.7 205.7 4.7 188.3 43.1 16.2 213.6 4.1 177.1 46.2 11.8 213.9 17.3 188.4 39.1 19.2 217.7 32.4 188.5 44.4 14.5 217.7 32.4 188.4 39.1 19.2 217.7 32.4 188.5 4.4 14.5	159.7	170.1	47.6	10.4	208.5	2.9	50.5
165.4 65.0 28.2 202.3 3.7 162.0 65.8 25.1 202.9 4.2 176.1 65.4 26.7 202.9 4.2 177.9 55.0 20.0 212.9 9.5 174.9 55.0 20.0 210.8 12.6 175.2 55.1 10.0 213.9 17.0 175.2 55.1 10.0 213.0 4.1 177.2 56.3 16.7 205.7 4.7 169.2 71.9 26.4 209.0 4.1 177.1 46.2 11.8 213.9 17.2 177.1 46.2 11.8 213.9 17.3 188.3 64.1 16.2 217.4 33.0 188.4 39.1 19.2 217.4 33.0 188.5 44.4 14.5 217.4 33.0 188.4 39.1 19.2 217.4 33.0 189.5 47.4 14.5 <t< td=""><td>160.8</td><td>171.3</td><td>52.1</td><td>10.5</td><td>208.9</td><td>3.8</td><td>55.9</td></t<>	160.8	171.3	52.1	10.5	208.9	3.8	55.9
162.0 65.8 25.1 202.9 4.2 163.7 65.4 26.7 202.6 3.9 176.1 53.1 20.0 212.9 9.5 174.9 57.0 20.0 210.8 12.6 175.5 55.1 19.0 21.3 19.1 175.2 55.0 20.0 213.4 19.1 175.2 55.1 17.5 213.6 19.1 175.2 53.6 18.3 213.0 19.4 167.4 56.3 16.7 205.7 4.7 168.3 71.9 26.4 209.0 4.1 169.2 71.9 26.4 209.0 4.1 169.2 71.9 26.4 205.0 4.7 169.2 71.9 26.1 20.0 4.7 169.2 71.1 21.0 21.2 20.1 177.0 49.5 11.2 21.2 21.2 188.3 44.4 14.5 217	137.2	165.4	65.0	28.2	202.3	3.7	68.7
163.7 65.4 26.7 202.6 3.9 176.1 53.1 20.0 212.9 9.5 174.0 55.0 20.0 210.8 12.6 175.5 55.1 19.0 213.4 11.0 175.5 55.1 19.0 213.4 19.1 175.5 55.1 19.0 213.4 19.1 175.2 55.1 17.5 212.6 19.1 169.2 71.9 26.4 209.0 4.1 169.2 71.9 26.4 209.0 4.1 169.2 71.9 26.4 209.0 4.1 169.2 71.9 26.4 209.0 4.1 177.0 49.5 11.9 213.9 17.2 188.3 44.4 14.5 217.7 32.4 188.4 39.1 19.2 217.7 32.4 188.5 44.4 14.5 217.7 32.4 188.0 41.8 16.8 <	136.9	162.0	65.8	25.1	202.9	4.2	69.6
176.1 53.1 20.0 212.9 9.5 171.9 57.0 20.0 210.8 12.6 174.0 55.0 20.0 213.4 19.7 174.9 55.1 19.0 213.4 19.1 174.9 52.1 17.5 212.6 4.7 175.2 53.6 18.3 213.6 4.7 167.4 56.3 16.7 205.7 4.7 168.2 71.9 26.4 209.0 4.1 168.3 64.1 21.6 207.4 4.4 168.3 64.1 21.6 209.0 4.1 177.0 49.5 11.9 213.9 18.5 177.1 46.2 11.8 213.9 18.5 188.4 39.1 19.2 217.4 33.0 188.4 39.1 19.2 217.6 32.7 188.4 39.1 19.2 217.4 33.0 162.7 44.4 14.5 <t< td=""><td>137.1</td><td>163.7</td><td>65.4</td><td>26.7</td><td>202.6</td><td>3.9</td><td>69.3</td></t<>	137.1	163.7	65.4	26.7	202.6	3.9	69.3
171.9 57.0 20.0 210.8 12.6 174.0 55.0 20.0 211.9 11.0 175.5 55.1 19.0 213.4 19.7 175.2 55.1 19.0 213.4 19.7 175.2 55.1 17.5 212.6 19.1 167.4 56.3 16.7 209.0 4.1 168.3 64.1 21.6 209.0 4.1 168.3 64.1 21.6 207.4 4.4 177.2 43.0 11.6 213.9 17.2 177.1 46.2 11.8 213.9 17.2 189.4 44.4 14.5 217.7 32.4 189.5 44.4 14.5 217.7 32.4 189.6 41.8 16.9 217.2 5.9 180.7 44.4 14.5 217.7 32.7 160.2 44.6 33.2 201.2 29.7 162.7 44.6 33.2	156.1	176.1	53.1	20.0	212.9	9.5	62.5
174.0 55.0 20.0 211.9 11.0 175.5 55.1 19.0 213.4 19.7 176.2 55.1 19.0 213.4 19.7 175.2 55.1 17.5 212.6 19.1 167.4 56.3 16.7 205.7 47.1 168.2 77.9 26.4 209.0 4.1 168.3 64.1 21.6 207.4 4.4 177.2 43.0 11.6 213.9 17.2 177.0 49.5 11.9 213.9 17.2 188.4 39.1 11.6 213.9 17.3 188.4 39.1 11.6 217.7 32.7 188.9 41.8 16.2 217.7 32.7 189.5 44.4 14.5 217.7 32.7 180.0 41.8 16.8 210.0 211.2 5.9 160.2 44.4 14.5 210.7 32.7 162.7 44.6	151.9	171.9	27.0	20.0	210.8	12.6	9.69
176.5 55.1 19.0 213.4 19.7 174.9 52.1 17.5 212.6 19.1 167.4 56.3 16.7 205.7 4.7 168.2 71.9 26.4 209.0 4.1 168.3 64.1 26.4 209.0 4.1 168.3 64.1 21.6 207.4 4.1 172.0 49.5 11.9 213.9 18.5 177.0 49.5 11.9 213.9 17.9 188.4 39.1 19.2 217.4 33.0 188.9 44.4 14.5 217.7 32.4 188.0 41.8 16.9 217.7 32.4 188.0 41.8 16.9 217.7 32.4 162.7 44.6 33.2 20.1 5.9 162.7 44.6 33.2 20.1 5.9 162.7 44.6 33.2 20.1 15.1 163.7 42.4 16.4	154.0	174.0	55.0	20.0	211.9	11.0	66.1
174.9 52.1 17.5 212.6 19.1 175.2 53.6 18.3 213.0 19.4 167.4 56.3 16.7 205.7 4.7 168.3 64.1 21.6 209.0 4.1 168.3 64.1 21.6 207.4 4.4 177.2 43.0 11.9 213.8 17.9 177.1 46.2 11.8 213.9 17.9 188.4 39.1 19.2 217.4 33.0 188.6 39.1 19.2 217.4 33.0 189.5 44.4 14.5 217.7 32.4 189.0 41.8 16.9 217.7 32.4 160.2 44.6 32.7 201.2 59.7 162.7 44.9 35.7 202.6 37.5 162.7 49.9 35.7 202.6 37.5 162.7 49.9 35.7 202.6 37.5 174.3 42.4 16.4	156.5	175.5	55.1	19.0	213.4	19.7	74.8
175.2 53.6 18.3 213.0 19.4 167.4 56.3 16.7 205.7 4.7 168.2 71.9 26.4 209.0 4.1 168.3 64.1 21.6 207.4 4.4 177.2 49.5 11.6 213.8 17.9 177.1 46.2 11.8 213.9 17.9 188.4 39.1 19.2 217.4 33.0 188.5 44.4 14.5 217.7 32.4 189.5 44.4 14.5 217.7 32.4 189.0 41.8 16.9 217.2 32.7 189.0 41.8 16.9 217.6 32.7 160.2 44.4 14.5 210.7 32.4 162.7 44.6 32.2 201.2 29.7 162.7 47.2 34.5 201.2 29.7 163.7 42.4 16.4 212.1 15.1 174.0 48.3 16.4	157.4	174.9	52.1	17.5	212.6	19.1	71.2
167.4 56.3 16.7 205.7 4.7 169.2 71.9 26.4 209.0 4.1 168.3 64.1 21.6 213.8 17.2 177.0 49.5 11.9 213.9 17.9 177.1 46.2 11.9 213.9 17.9 188.4 39.1 19.2 217.4 33.0 188.5 44.4 14.5 217.7 32.4 189.0 41.8 16.9 217.6 32.7 172.0 55.5 8.2 210.1 5.9 172.0 44.6 33.2 201.2 5.9 160.2 44.9 35.7 202.6 37.5 161.5 47.2 34.5 201.2 29.7 161.5 47.2 34.5 201.2 37.6 161.5 47.2 34.5 201.2 37.6 174.0 48.3 16.4 212.1 17.1 173.7 65.0 31.2	157.0	175.2	53.6	18.3	213.0	19.4	73.0
169.2 71.9 26.4 209.0 4.1 168.3 64.1 21.6 207.4 4.4 177.2 43.0 11.6 213.9 17.2 177.1 46.2 11.8 213.9 17.3 177.1 46.2 11.8 213.9 17.3 188.4 39.1 19.2 217.7 32.4 189.5 44.4 14.5 217.7 32.4 189.0 41.8 16.8 217.7 32.7 189.0 41.8 16.9 217.7 32.7 189.0 41.8 16.9 217.7 32.7 160.2 56.5 10.0 211.2 5.9 172.0 55.5 8.2 210.1 5.9 160.2 44.6 33.2 201.2 29.7 161.5 47.4 16.4 212.1 15.1 174.0 48.3 16.4 212.1 16.3 174.1 65.0 31.2	150.7	167.4	56.3	16.7	205.7	4.7	60.5
168.3 64.1 21.6 207.4 4.4 177.2 43.0 11.6 213.8 17.2 177.1 46.5 11.9 213.9 17.8 177.1 46.2 11.9 213.9 17.8 188.4 39.1 19.2 217.4 33.0 188.0 41.8 16.9 217.6 32.7 189.5 44.4 14.5 217.6 32.7 180.0 41.8 16.9 217.6 32.7 172.0 56.5 10.0 211.2 5.9 172.0 56.5 10.0 211.2 5.9 162.7 44.6 33.2 200.1 5.9 162.7 44.6 33.2 201.2 5.9 162.7 44.6 35.1 202.6 5.9 162.7 42.4 16.4 212.1 15.1 174.0 48.3 16.6 212.4 16.3 174.1 65.0 31.2 <	142.8	169.2	71.9	26.4	209.0	4.1	76.0
177.2 43.0 11.6 213.8 17.2 177.0 49.5 11.9 213.9 18.5 188.4 39.1 19.2 217.4 33.0 188.6 39.1 19.2 217.4 33.0 189.5 44.4 14.5 217.6 32.7 189.0 41.8 16.9 217.6 32.7 180.0 41.8 16.9 217.6 32.7 172.0 56.5 10.0 211.2 5.9 172.0 56.5 10.0 211.2 5.9 160.2 44.6 33.2 201.2 29.7 160.2 44.6 33.2 201.2 29.7 161.5 47.2 34.5 201.9 33.6 173.7 54.2 16.7 212.7 17.5 174.0 48.3 16.6 212.4 16.3 174.1 65.0 31.2 212.1 17.1 173.7 62.2 31.3	146.8	168.3	64.1	21.6	207.4	4.4	68.4
177.0 49.5 11.9 213.9 18.5 177.1 46.2 11.8 213.9 17.9 188.4 39.1 14.5 217.4 33.0 189.5 44.4 14.5 217.7 33.2 189.0 41.8 16.2 217.7 32.4 189.0 41.8 16.2 217.7 32.7 172.0 55.5 8.2 210.1 5.9 172.0 55.6 8.2 210.1 5.9 160.2 44.6 33.2 201.2 29.7 161.5 44.6 33.2 201.2 29.7 161.5 47.2 34.5 201.9 37.5 161.5 47.2 34.5 201.9 37.6 173.7 54.2 16.7 212.7 17.5 173.7 54.2 16.7 212.7 17.6 173.7 62.2 31.3 212.6 16.6 173.4 67.8 35.1	165.6	177.2	43.0	11.6	213.8	17.2	60.2
177.1 46.2 11.8 213.9 17.9 188.4 39.1 19.2 217.4 33.0 188.5 44.4 14.5 217.7 32.4 189.0 41.8 16.9 217.6 32.7 173.7 56.5 8.0 217.2 5.9 172.0 55.5 8.1 210.1 5.9 160.2 44.6 33.2 201.2 29.7 162.7 49.9 35.7 202.6 37.5 161.5 47.2 34.5 201.9 33.6 174.3 42.4 16.4 212.1 15.1 173.7 54.2 16.7 212.1 15.1 173.7 54.2 16.7 212.1 16.8 173.7 62.2 31.2 212.6 17.1 173.4 62.9 31.2 212.6 16.8 173.4 64.9 19.7 21.9 6.1 173.4 64.9 19.7 <	165.1	177.0	49.5	11.9	213.9	18.5	.89
188.4 39.1 19.2 217.4 33.0 189.5 44.4 14.5 217.7 32.4 189.0 41.8 16.9 217.6 32.7 172.0 56.5 10.0 211.2 5.9 172.0 55.5 8.2 210.1 5.9 160.2 44.6 33.2 201.2 29.7 160.2 44.6 33.2 201.2 29.7 162.7 49.9 35.7 202.6 37.5 161.5 47.2 34.5 201.9 33.6 174.3 42.4 16.4 212.1 15.1 173.7 54.2 16.7 212.7 17.5 174.3 42.4 16.4 212.1 16.3 173.7 62.2 31.2 212.1 16.8 174.4 67.8 35.1 212.6 17.1 169.6 50.3 17.1 206.8 62 173.4 64.9 19.7	165.4	177.1	46.2	11.8	213.9	17.9	64.1
189.5 44.4 14.5 217.7 32.4 188.0 41.8 16.9 217.6 32.7 172.0 56.5 10.0 211.2 5.9 172.0 56.5 10.0 211.2 5.9 172.0 56.5 9.1 210.1 5.9 160.2 44.6 33.2 201.2 29.7 162.7 49.9 35.7 202.6 37.5 161.5 47.2 34.5 201.9 33.6 174.3 42.4 16.4 212.1 15.1 173.7 54.2 16.7 212.7 17.5 174.3 42.4 16.4 212.1 15.1 173.7 54.2 16.7 212.7 17.5 174.4 67.8 35.1 212.6 17.1 169.6 50.3 17.1 206.8 6.2 173.4 64.9 19.7 21.9 6.1 176.8 40.5 9.0 <td< td=""><td>169.2</td><td>188.4</td><td>39.1</td><td>19.2</td><td>217.4</td><td>33.0</td><td>72.1</td></td<>	169.2	188.4	39.1	19.2	217.4	33.0	72.1
189.0 41.8 16.9 217.6 32.7 172.0 56.5 10.0 211.2 5.9 172.0 56.5 10.0 211.2 5.9 172.0 56.0 9.1 210.7 5.9 160.2 44.6 33.2 201.2 29.7 162.7 49.9 35.7 202.6 37.5 161.5 47.2 34.5 201.9 33.6 174.3 42.4 16.4 212.1 15.1 173.7 54.2 16.7 212.7 17.5 174.4 67.8 35.1 212.6 16.8 173.7 65.0 33.2 212.1 16.8 174.4 67.8 35.1 212.6 16.8 173.7 65.0 33.2 212.1 6.2 173.4 64.9 19.7 21.9 6.1 171.5 57.6 18.4 209.4 6.2 176.8 40.5 9.0	175.0	189.5	44.4	14.5	217.7	32.4	76.8
173.7 56.5 10.0 211.2 5.9 172.0 55.5 8.2 210.1 5.9 160.2 46.0 39.1 210.7 5.9 160.2 44.9 35.7 202.6 37.5 161.5 47.2 34.5 201.9 33.6 174.3 42.4 16.4 212.1 15.1 174.0 48.3 16.6 212.4 16.3 174.4 67.8 35.1 21.6 16.8 173.7 65.0 31.2 212.6 16.8 174.4 67.8 35.1 21.6 16.8 174.4 65.0 31.2 212.6 16.6 174.4 65.0 31.2 212.6 16.8 174.4 65.0 31.2 212.1 16.8 174.6 50.6 60.8 6.2 17.1 57.6 18.4 209.4 6.2 177.0 54.3 12.7 214.3	172.1	189.0	41.8	16.9	217.6	32.7	74.4
172.0 55.5 8.2 210.1 5.9 172.9 56.0 9.1 210.7 5.9 160.2 44.6 33.2 201.2 37.5 161.7 49.9 35.7 202.6 37.5 161.5 47.2 34.5 201.1 33.6 174.3 42.4 16.4 212.1 15.1 173.7 54.2 16.7 212.7 17.5 174.0 48.3 16.6 212.4 16.3 174.4 67.8 35.1 211.6 17.1 173.7 62.2 31.3 212.6 16.6 174.1 65.0 31.2 212.1 16.8 169.6 50.3 17.1 206.8 6.2 173.4 64.9 19.7 211.9 6.1 176.8 40.5 9.0 214.2 14.6 177.0 54.3 12.7 214.3 17.4	163.7	173.7	56.5	10.0	211.2	5.9	62.4
172.9 56.0 9.1 210.7 5.9 160.2 44.6 33.2 201.2 29.7 162.7 44.9 35.7 202.6 37.5 161.5 47.2 34.5 201.9 33.6 173.7 54.2 16.7 212.7 17.5 174.0 48.3 16.6 212.4 16.3 174.4 67.8 35.1 211.6 17.1 173.7 62.2 31.3 212.6 16.6 173.4 65.0 37.2 212.1 16.8 169.6 50.3 17.1 206.8 6.2 173.4 64.9 19.7 21.9 6.1 171.5 57.6 18.4 209.4 6.2 176.8 40.5 9.0 214.2 14.6 177.0 54.3 12.7 214.3 17.4	163.8	172.0	55.5	8.2	210.1	5.9	61.4
160.2 44.6 33.2 201.2 29.7 162.7 49.9 35.7 202.6 37.5 161.5 47.2 34.5 201.9 33.6 174.3 42.4 16.4 212.1 15.1 173.7 54.2 16.7 212.7 17.5 174.0 48.3 16.6 212.4 16.3 173.7 62.2 31.3 212.6 16.6 174.4 65.0 31.3 212.6 16.6 173.7 62.0 31.7.1 206.8 6.2 173.4 64.9 19.7 211.9 6.1 173.4 64.9 19.7 211.9 6.1 177.5 57.6 18.4 209.4 6.2 176.8 40.5 9.0 214.2 14.6 177.0 54.3 12.7 214.3 17.4	163.8	172.9	56.0	9.1	210.7	5.9	61.9
162.7 49.9 35.7 202.6 37.5 161.5 47.2 34.5 201.9 33.6 174.3 42.4 16.4 272.1 15.1 173.7 54.2 16.7 212.7 17.5 174.0 48.3 16.6 212.4 16.3 173.7 62.2 31.3 212.6 16.6 174.1 65.0 31.2 212.6 16.6 173.7 62.0 31.7 206.8 6.2 173.4 64.9 19.7 211.9 6.1 173.4 64.9 19.7 211.9 6.1 173.6 57.6 18.4 209.4 6.2 176.8 40.5 9.0 214.2 14.6 177.0 54.3 12.7 214.3 17.4	127.0	160.2	44.6	33.2	201.2	29.7	74.4
161.5 47.2 34.5 201.9 33.6 174.3 42.4 16.4 212.1 15.1 173.7 54.2 16.7 212.7 17.5 174.0 48.3 16.6 212.4 16.3 173.7 62.2 31.3 212.6 17.1 173.7 62.0 31.2 212.6 16.6 173.4 64.9 19.7 21.9 6.1 173.4 64.9 19.7 21.9 6.1 171.5 57.6 18.4 209.4 6.2 176.8 40.5 9.0 214.2 14.6 177.0 54.3 12.7 214.3 17.4	127.0	162.7	49.9	35.7	202.6	37.5	87.4
174.3 42.4 16.4 212.1 15.1 173.7 54.2 16.7 212.7 17.5 174.0 48.3 16.6 212.4 16.3 174.4 67.8 35.1 211.6 17.1 173.7 62.2 31.3 212.6 16.8 169.6 50.3 17.1 206.8 6.2 173.4 64.9 19.7 21.9 6.1 171.5 57.6 18.4 209.4 6.2 176.8 40.5 9.0 214.2 14.6 177.0 54.3 12.7 214.3 17.4	127.0	161.5	47.2	34.5	201.9	33.6	80.9
173.7 54.2 16.7 212.7 17.6 174.0 48.3 16.6 212.4 16.3 174.4 67.8 35.1 211.6 17.1 173.7 65.0 31.2 212.6 16.8 169.6 50.3 17.1 206.8 6.2 173.4 64.9 19.7 211.9 6.1 171.5 57.6 18.4 209.4 6.2 176.8 40.5 9.0 214.2 14.6 177.0 54.3 12.7 214.3 17.4	157.9	174.3	42.4	16.4	212.1	15.1	57.5
174.0 48.3 16.6 212.4 16.3 174.4 67.8 35.1 271.6 17.1 173.7 62.2 31.3 272.6 16.6 169.6 50.3 17.1 206.8 6.2 173.4 64.9 19.7 211.9 6.1 171.5 57.6 18.4 209.4 6.2 176.8 40.5 9.0 214.2 14.6 177.0 54.3 12.7 214.3 17.4	157.0	173.7	54.2	16.7	212.7	17.5	71.7
174.4 67.8 35.1 211.6 17.1 173.7 62.2 31.3 212.6 16.6 174.1 65.0 33.2 212.1 16.8 169.6 50.3 17.1 206.8 6.2 173.4 64.9 19.7 211.9 6.1 171.5 57.6 18.4 209.4 6.2 176.8 40.5 9.0 214.2 14.6 177.0 54.3 12.7 214.3 17.4	157.5	174.0	48.3	16.6	212.4	16.3	64.6
173.7 62.2 31.3 212.6 16.6 174.1 65.0 33.2 212.1 16.8 169.6 50.3 17.1 206.8 6.2 173.4 64.9 19.7 211.9 6.1 171.5 57.6 18.4 209.4 6.2 176.8 40.5 9.0 214.2 14.6 177.0 54.3 12.7 214.3 17.4	139.3	174.4	67.8	35.1	211.6	17.1	84.6
174.1 65.0 33.2 212.1 16.8 169.6 50.3 17.1 206.8 6.2 173.4 64.9 19.7 211.9 6.1 171.5 57.6 18.4 209.4 6.2 176.8 40.5 9.0 214.2 14.6 177.0 54.3 12.7 214.3 17.4	142.4	173.7	62.2	31.3	212.6	16.6	78.7
169.6 50.3 17.1 206.8 6.2 173.4 64.9 19.7 211.9 6.1 171.5 57.6 18.4 209.4 6.2 176.8 40.5 9.0 214.2 14.6 177.0 54.3 12.7 214.3 17.4	140.9	174.1	65.0	33.2	212.1	16.8	81.8
173.4 64.9 19.7 211.9 6.1 171.5 57.6 18.4 209.4 6.2 176.8 40.5 9.0 214.2 14.6 177.0 54.3 12.7 214.3 17.4	152.5	169.6	50.3	17.1	206.8	6.2	56.5
171.5 57.6 18.4 209.4 6.2 176.8 40.5 9.0 214.2 14.6 177.0 54.3 12.7 214.3 17.4	153.7	173.4	64.9	19.7	211.9	6.1	71.0
176.8 40.5 9.0 214.2 14.6 177.0 54.3 12.7 214.3 17.4	153.1	171.5	57.6	18.4	209.4	6.2	63.7
177.0 54.3 12.7 214.3 17.4	167.8	176.8	40.5	9.0	214.2	14.6	55.1
	164.3	177.0	54.3	127	2143	17.4	7.4

Cycle Type: Scan Condition Sample ID 1-25 70/20/10
5 5 5
6 6
S S

Semple I.D.	10	-	2	3	4	5	9		60	88	6	98	12
POLYMER TYPE MBM/schnic &	Blend	Blend	Blend	Blend	Blend	Blend	Blend	Blend	Biend	Blend	Blend	Blend	
Bodam blends	#10	#	2	#3	#	#2	#	#7	\$	88#	₽	#88	MBM
Feeder Setting 1.13	1.13	1.13	1.13	1.13	1.13	1.13	1.13	1.13	1.13	1.13	1.13	1.13	1.13
							ļ.	10	i	627	Special 277	E(0.0)	
	ь	uo	5	5	5	Б	5	5	ا ا	8	5	8	5
	220	215	215	215	215	215	215	215	215	215	215	223	258
zone 2 Temp. (deg c) 215	220	215	215	215	215	215	215	215	215	215	215	223	258
	220	215	215	215	215	215	215	215	215	215	215	223	258
	220	215	215	215	215	215	215	215	215	215	215	223	258
	220	215	215	215	215	215	215	215	215	215	215	223	258
zone 6 Temp. (deg c) 210	220	210	210	210	210	210	210	210	210	210	210	218	258
zone 7 Temp. (deg c) 210	j	210	210	210	210	210	210	210	210	210	210	218	258
8 Connecting Plate Temp. (deg. C) 213	l	213	213	213	213	213 .	213	213	213	213	213	221	258
Ì		213	213	213	213	213	213	213	213	213	213	220	258
10 Spin Pump Temp. (deg.C) 215	220	215	215	215	215	215	215	215	215	215	215	222	258
	220	215	215	215	215	215	215	215	215	215	215	222	258
12 Spin Pack Temp. (deg.C) 216	220	216	216	216	216	216	216	216	216	216	216	226/223	258
Barrel Men Temp. (deg. c)	225	218	218	218	218	218	218	218	218	217	217	225	264
Meft Pump Inlet Pressure (psi)	220	850	1210	670	630	910	1340	920	450	760	470	1400	680
let Pressure (psi)	900	330	460	520	520	420	260	430	460	470	620	390	570
Extruder (rpm) 200	200	200	200	200	200	200	200	200	200	200	200	200	200
Monomer Exhaust inches water			- 1										
Spinneret: no. of holes / Shape		6R	æ	98 8		88	SR SR	6R	88	SR.	6R	6R	Se Se
Spinneret: capilary diameter & depth	9	.01778x.061	.01778x.061	.01778x.061	361	.01778x.061	.01778x.061	.01778x.061	.01778x.061	.0177x .061	.0177x .061	.0177x .061	.0177x .061
Metering pump size (cc/rev)	T	1.16	1.16	1.16	1.18	1.16	1.18	1.16	1.16	1.16	1.16	1.16	1.16
merering pump (rpm)	c)		7.5	7.5	7.5		7.5	7.5	7.5	7.5	7.5	7.5	7.5
ו שנה שת (ומצישי)		3	1.13	1.13	1.13	1.13	1.13	1.13	1.13	1.13	1.13	1.13	1.13
Filter type	N.	E.	STD SCREEN	S	STD SCREEN	STD SCREEN	SCREEN	STD SCREEN	STD SCREEN	STD SCREEN	STD SCREEN	STD SCREEN	STD SCREEN
Quench air Flow rate (CF/M)	7.1	٦	7.4	7.3	7.5	7.4	7.2	7	7.4	6.9	7	7.1	7.1
Gench air Temp. (deg. c)	20.1	19.9	18.3		19.3	18.8	18.5	18.4	18.5	19.9	18.9	18.2	18.5
Cuench air Humidity %	54.5		45.2		52.5	49.7	50.1	52.4	53.6	51	39.4	52.1	36.8
% lorque	21		27		25	22	58	22	21	22	22	28	23
Nitrogen in Hoper	3	3	9	Г	က	6	6		6	67			
Need : polymer chips moisture	yes			-									
										1			

	9	Blend	Blend	Blend	Blend	Biend	Blend	Blend	Blend		Blend	Blend	Blend	Blend	Blend	Blend	Blend	Blend	
Sample I.D.	ş	10-2	និ	ī	?	?	7	_	2-3		2	I	5	I	5.7	£.	ş	3	Į
POLYMER TYPE Nyon Bland	9	2	2	- -	-	-	2	2	2	Comments	10	40	80	40	6	•		9	
							-	-							-				
SAMPLE START TIME	13:35	14:25	15:15	9:30	96:36	9:20	10:19	11:08	11:27	Hard to string up-	8.20	R-33	95.8	05:45	04.6	10:01	10:55	11:33	11.55
SH TIME	14:20	5.10	15:40	8:34	9:18	10:05	11:04	11:22	12:10		12.0	3	9:2H	9.35	848	10:52	22.50	11:53	12:14
ln)	48	45	×	7	45	45	45	91	45	RxT-2 #1 roff to 2090	, m	1.	31 min	4 min	de e	45 min	•	S min	19 min
7-10	F-137-10	F-137-10	F-137-10	137-1	F-137-1	F-137-1	F-137-1 F	1 F-137-10 F-137-10	-137-10	again.	E 137 40	-	1.	14	ju			F-137-10	F-137-10
Kiss roll (rpm)	3.0	3.0	9	3.4	3.4	┢	3.8	3.8	3.8	then raised back up to							3.67	187	.87
	9.5%		9.5%							4090 after number on	3.0	3.0	3.6	2.0	9	9	(0.0)	9	5
RXT.	060*	4090	4090	960	4090	980	980	9604	4090	winder	7007	7007	400	400	807	4000	4080	0607	4090
SMALL Roll #2 SPEED (m/min)		Ĺ									6	B	200	8	3				
LARGE Roll #3 SPEED (m/min)	L					Ī	 								1				
LARGE Roll # 4 SPEED (m/min.) RXT-1	4090	9603	4090	060*	960	960	4090	6090	980		4000	4000	4000	4000	4000	900	4090	4090	4090
Entangling								ļ											
jet type	L								Γ										ļ
atr to jet (pal)																Ì			
Winder grove roll: Speed (mimin.)	4499	4499	L	4499	4499	4499	4488	⊢	4499		9007	7700	4409	4490	644	4489	4499	4499	4489
Winder drive roll: Speed (mimin.	4090	4080	4090	4090	4080	9603	4090	680	980		4080	0807	4090	4080	4090	080	4080	6090	4080
Undrawn Denter	20.0			20.0	20.0	20.0										8			
Need: undrawn yem Danier, instron															Ī				
, free fall FAV (after each run set)														Ī	1				İ
submit free fall and polymer for FAV							l	\mid										Ī	
Monther Parents inches water					İ	İ	ŧ	-					_		-	-		_	

	Blend	Blend	Blend	Blend	Blend	Blend	Blend	Blend	Blend	Blend	Blend	Bland Ble	Blend Blend	nd Blend	Blend	Blend	Blend	Blend 7-10	Blend 7-11	Blend 8-1	Blend Bl	Blend Bl	Blend Blend 8-4 8-6	Blend 8-6
Sempte I.D.	Ā	3	3	ş	7	2	┼	┼—	<u> Т. </u>	+-	┿	╫	┼─	+	╁	╁╌		·		•	-			
POLYMER TYPE Nyton Bland		3	3	-	7	4	-	اء ا	<u></u>	-	7		7	_	1	-	_	1	Ť	,	 	ļ	L	
.:						4		-	Ц Т	Н	4		┪	┥	4	+		17.81	18.05	9.15	10:10	1-		5 10:55
SAMPLE START THE	12:38	13:23	14:15	14:45	15:07	4		4	8	12:35	12:49	12:57 13	13:28 13:40	13:54	14:02	4	2	Ę	15:10	9:38	┖	10.25		
SAMPLE FINSH TIME	1:15	14:08	14:25	14:54	15:52	16:23	18:50	-	L		_		_	4	+	┧	9		ŧ.	ZI min	┖	1		_
Run time (min)	25 min	45 min	10 mm	HILL B	45 min	18 min	21 mln ; 7	П		L	H	9 min 12	12 mln 4 mln	ıİn 6 mb		F	- 1	457.40	E 437.40	6	-	ю	F-137-10 F-137-10	_
Finish type F-137-10	F-137-10	F-137-10 F-137-10	F-137-10	F-137-10	F-137-10	E-137-10 F	F-137-10 F-137-10 F-137-10 F-137-10 F-137-1	0	위	F-137-10 F-	F-137-10 F-1	F-137-10 F-13	10 F	Ŀ	ď.	٤	إ		287	3.87	167	4		-
1	3.8	3.8	3.8	8,	3.8	3.8	3.6	3.8	3.6	L	3.67	3.67 3.	3.67 3.67	79.67	7 3.67	3.67	3.67	10.0	000	Ť	i.	-	+	╀
Godeta:	L					-				-			H	H	Н	Н		4047	4000	4000	4000	4080	4090	080*
SMALL Red of SPEED (m/min) RxT-2	980	4080	4090	980	88	4090	4090	4090 4	4090	4090	4090	4090 40	4090 4090	4090	0 4090	4090	4080	200			╀	╀	╀	H
SMALL Roll #2 SPEED (m/min)	-									L		_								Ì		-		-
LARGE Roll #3 SPEED (m/mtn)							Н	Н				-	Н	Н	\dashv	4		4000	0807	4080	4080	4080	4090 4090	4090
LARGE Roll # 4 SPEED (mimin.) RXT-1	4080	4090	4080	4090	4090	4090	4090	4080	4080	4090	4090	4090	4090 4090	4090	4090	4090	4090				╀	-		
Entangling							4		ļ													-	L	-
et type	 -						-				-	_		1		-						-		-
afr to jet (pel)	L							┨		\dashv	+	\dashv	\dashv	4	\dashv	4		0677	4499	4488	┝	-	499 4499	64499
Winder grove roll; Speed (mimin.)	4499	4489	4499	4488	4489	4499	-	4499	4499	4488	4499 4	4499	4489 4489	4499	4498	28	8	4000	0807	4080	4080	4080	4090	H
Whider drive roll: Speed (minth.	4090	4080	4080	4080	4090	4080	4090	4	080	Н	Н	-		Н	-	4	86			200	╀	┝	H	H
Undrawn Denter			L					-	0.0	2	-		_	_								-		-
	-					-	-	-	Γ	-		-	-	_	L				1			-		+
					 		-	ŀ	L.	-		-	L	L	-				1		+	-	-	-
Need: undrawn yarn Denier, Instron						-				-	-	-				·						-		-
, free fall FAV (after each run set)	L						-		L.,										1			-		-
submit free fall and polymer for FAV									П	H			_								l	-		-
Monomer Exhaust inches water	L																							
						Ì																		

Semple I.D.		Blend 88-1	Blend 88-2	Blend Blend 68-3	Bend 88.4	Blend Bi	Blend Ble 88-6 88	Blend Ble 8B-7 68	Blend Blend 68-6 68-9	B 8	Blend Blend Blend Blend Blend 68-6 68-9 88-10 68-11 9-1	Blend 1-1	2 g	ğ 3	ğı	£ 2	Send Se	Blend 98-1	Comments	Samela I.O.
POLYMER TYPE Nylon Blend	Blend		8	2	2	- 2	- 8		. 88		\$	•	•	•	•		6	•	Temp.change up to 225 degrees	POLYMER TYPE N
		gangerett.			H	╀	┼-	⊢	╀	╀╌	╀	L	L	Ĺ				1		
SAMPLE START TIME		90.6	2	9	8	51:0	82	8	50	5:5	9-40 10:05 10:15 10:20 10:30 10:30 11:10 11:30 11:40 13:20 14:30 14:00 14:25 15:00 15:15 16:00	13.20	13:30	8.4	14:25	15.00	15:15	90.91		SAMPLE START TIME
SAMPLE FINISH TIME		8.20	22	9:50	0::0	91:0	124	10:	55 11:	=	10:10 10:16 10:24 10:45 10:55 11:25 11:37 11:51 13:25 13:58 14:13 14:46 15:09 15:44	13.25	5	14:13	1.66	500	15.4	ē		SAMPLE FINISH TIME
Run time (min)		2	-	2	~	-	•	15	5	-	=	•	2	2	×	•	R	-		Ę.
Finish type F-137-10		F-137-10	Γ	T	t	┢	-	\vdash	\vdash	\perp	L	L	L					T		Finish type F-1:
Kiss roll (rpm)		3.65		 	t	H	H	-	<u> </u>	! -	L	_						İ		Kiss roll (rpm)
Godets:			Γ	T	t	-	H	\vdash	F	\vdash	L	L	L					T		Godets:
SMALL Roll #1 SPEED (m/min) RXT-2	EXT-2	86	Γ	T	t		1	+	L	L	Ĺ	-	L	Ĺ			Γ	T		SMALL Roll #1 SPEED (m/i
SMALL Roll #2 SPEED (m/min)			Γ		t	H	\vdash	-	L	L	-	L	L	Ĺ				T		SMALL Roll #2 SPEED (m/r
LARGE Roll #3 SPEED (m/min)				-	H	+	-	-	L	L	L	-		Ĺ	I			T		LARGE Roll #3 SPEED (m/i
LARGE Roll # 4 SPEED (m/min.)	RXT-1	4080			\vdash	\vdash	H	-	\vdash	╀	-	-			I			1		LARGE Roll # 4 SPEED (m/m)
Entangling				H	┢	\vdash	\vdash	L	H	-	L	L	L					İ		Entangling
lat type			Г	r	H	\vdash	\vdash	\vdash	H	L	L	_	L		Ŀ			T		Jet type
air to jet (psi)			T	-	H	<u> </u>	L	-	-	-							1			air to jet (psi)
Winder grove roll: Speed (m/min.)		823	Γ	f	\vdash	\vdash	\vdash	\vdash	\vdash	L	L	L	Ĺ				Ī	T		Winder grove roll: Speed (m/n
Winder drive roll: Speed (m/min.		9604		T	H	\vdash	L	\vdash	\vdash	L	Ļ	L	L			Γ	T	T		Winder drive roll: Speed (m/m
Undrawn Denler		20.0				H	L	\vdash	-	L	L						Γ	ē		Undrawn Denier
				1	H	H	H	Н	Н	Ц		Ц					П	П		
				1	+	+	\dashv	-	_		4									
Need: undrawn yarn Denier, instron	LO.				_	_	-	-		_	_							-		Need: undrawn yarn Denier,
, free fall FAV (after each run set)	set)				\vdash	-	\vdash	ŀ	<u> </u>	L	L	L	Ĺ					T		free fall FAV (after each
submit free fall and polymer for FAV	_		Г	H	H	H	\vdash	-	L	L	L	L				ľ	T	T		submit free fall and polymer for
Monomer Exhaust Inches water					H	\vdash	\vdash	-	-	\perp	L	L			I			T		Monomer Exhaust Inches wa
								I							•					

4499 4090 20.0

12-1 MBM

9B-1

8**B-1**

9-1

10-1

11-1

2.

7

2-5

4-2

6-1

300	Rate (C/min):		20	Hora (min)	ıın):	
			Melting Peaks			
Onset 1	1st Tm	∆Hf 1	Onset 2	2nd Tm	3rd Tm	∆Hf2
(2)	(၁)	(J/g)	<u></u>	(0)	(C)	(B/C)
137.2	148.5	3.5	178.6	182.3	215.3	52.2
137.9	149.2	3.7	178.8	182.3	215.3	52.5
137.6	148.9	3.6	178.7	182.3	215.3	52.3
127.3		3.7	177.7	180.8	214.3	58.3
125.8		3.9	177.8	181.1	215.4	28.8
126.6		3.8	177.8	181.0	214.9	58.6
138.7		3.2	176.0	178.2	212.9	50.1
138.3		3.2	175.9	178.0	213.5	51.5
138.5		3.2	176.0	178.1	213.2	50.8
135.3	L	3.9	179.1	183.1	215.7	56.3
137.2		4.0	179.1	183.0	215.6	57.2
1363		3.9	179.1	183.1	215.7	56.8
131 B		4.0	178.6	182.0		59.1
1201		4.2	179.9	184.9		57.5
130 5		4.1	179.3	183.5	215.8	58.3
1120		65	180.4	187.6		63.0
110.5		4.8	179 9	187.4		67.0
444.2		20.5	180.2	187.5		65.0
124			180 6	187.5		63.3
131.2				407.6		50 7
132.3		3.5	100.9	107.0		200.
131.8				0.701		
122.6			178.9	183.4	7.017	03.0
128.9				183.7	215.	5/.7
125.8	137.4			183.6	215.9	60.3
135.6	146.0		172.2	174.3		49.9
131.5			172.3	174.1		54.3
133.6			172.3	174.2		52.1
122.6	135.2			173.0		.09
116.2						.63
1194				173.2		62.
118.9					215.5	62.
1187				184.1	215.9	.19
118.8		4		184.1	_	62.0
125.6	L			188.4	L	
123.8			179.8	188.4		62.3
1247	137			188.4		61.
1221	L			181.9	L	61.7
121 5		43		182.1	L	60.2
424 B					215.2	
114 9						73.4
440 5						

Sample ID

1-2

2-1

3-1

RXT-2 Extrusion

Sample I.D.	98	06	90	36	9F
POLYMER TYPE MBM/technic & lactam blends	Blend #9	Blend #9	Blend #9	Blend #9	Blend #9
, c		•			· ·
and pulling advantage		o	6	o	uo
water oil recuing coile	220	230	240	250	260
Zone i temp: (deg c)	220	230	240	250	260
zone z temp. (deg c)	220	230	240	250	260
Tono A Tomp (deg c)	220	230	240	250	260
tone & Temp (deg c)	220	230	240	250	260
zone 6 Temp (deg c)	220	230	240	250	260
zone o temp: (acg c)	220	230	240	250	260
S Connecting Plate Temp. (deg. C)	220	230	240	250	260
o connecting that comp. (409: 4)	220	230	240	250	260
9 Block Tellip. (udg.c.) 40 Sain Dumn Temp (ded C.)	220	230	240	250	260
14 Ton Can (dea C)	220	230	240	250	260
11 10p Cap (ucg.c) 12 Snin Dack Temp (deg C)	220	230	240	250	260
Barrel Melt Temp. (deg. c)	225	235	245	255	265
Melt Pump Inlet Pressure (psi)					
Melt Pump Outlet Pressure (psi)					
Extruder (rpm)	200	200	200	200	200
Monomer Exhaust inches water			. !	ļ	
Spinneret: no. of holes / Shape	6R	6R	6R	6R	. 6K
Spinneret: capilary diameter & depth	.01778x.061	.01778x.061	.01778x.061	.01778x.061	.01778x.061
Metering pump size (cc/rev)	1.16	1.16	1.16	1.16	1.16
Metering pump (rpm)	7.5	7.5	7.5	7.5	7.5
Thrubut (lbs/hr)	1.13	1.13	1.13	1.13	1.13
Filter type	STD SCREEN	STD SCREEN	STD SCREEN	STD SCREEN	STD SCREEN
Quench air Flow rate (CF/M)	7.1	7.1	7.1	7.1	7.1
Qench air Temp. (deg. c)	20.1	20.1	20.1	20.1	20.1
Quench air Humidity %	54.5	54.5	54.5	54.5	54.5
% Torque	27	21	21	21	21
Nitrogen in Hoper	က	ო	ო	ო	ო
Need: polymer chips moisture	<u>8</u>				

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Sample I.D.			86	၁	О6	3	9 E
MER TYPE	Nylon Blend	pue	တ	6	6	တ	တ
SAMPLE START TIME SAMPLE FINISH TIME Run time (min) Finish type Kiss roll (rpm)			5-10 min F-137-10 3.7	5-10 min 5-10 min 5-10 min F-137-10 F-137-10 F-137-10 3.7 3.7 3.7	5-10 min F-137-10 3.7	5-10 min F-137-10 3.7	5-10 min F-137-10 3.7
Godets: SMALL Roll #1 SPEED (m/min)	/min)	RXT-2	4090	4090	4090	4090	4090
SMALL R 11 #2 STEED (11,000) LARGE Roll #3 SPEED (m/min) LARGE Roll # 4 SPEED (m/min.)	ı/min) nin.)	RXT-1	4090	4090	4090	4090	4090
jet type air to jet (psi) Winder grove roll: Speed (m/min.) Winder drive roll: Speed (m/min. Undrawn Denier	/min.) 'min.	÷	4499 4090 20.0	4499 4090 20.0	4499 4090 20.0	4499 4090 20.0	4499 4090 20.0

1			∆Hf 2	(J/g)	63.8	66.5	65.2	62.7	61.6	62.2	62.5	63.2	62.8	62.3	61.6	61.9	59.3	58.3		63.9	64.8	64.3	61.6	66.3	63.9
	nin):		3rd Tm	(c)	217.1	217.6	217.4	216.1	216.6	216.4	216.8	216.8	216.8	215.9	216.1	216.0	213.8	213.7	213.8	217.3	217.4	217.4	213.8	213.1	213.5
	Hold (min):		2nd Tm	(c)	190.4	190.8	190.6	186.2	186.4	186.3	189.2	189.2	189.2	189.6	189.9	189.8	187.0	187.0	187.0	190.1	189.4	189.8	186.4	185.5	186.0
	20	Melting Peaks	Onset 2	(c)	180.4	180.7	180.6	180.4	180.3	180.4	181.1	181.0	181.1	181.1	182.0	181.6	180.9	180.8	180.9	177.9	175.5	176.7	177.4	175.7	175.6
1st Heat Cycle	in):	A	∆Hf1	(J/g)	4.7	5.5	5.1	4.0	4.6	4.3	4.7	4.6	4.6	4.8	4.4	4.6	4.4	4.2	4.3						
1st H	Rate (C/min)		1st Tm	(3)	132.4	132.3	132.4	141.0	140.5	140.8	141.8	141.2	141.5		146.2	145.7	148.3	148.6	148.5						
	300		Onset 1	<u>(</u>)	119.1	118.1	118.6	128.8	128.2	128.5	129.0	129.2	129.1	132.6	134.4	133.5	137.2	136.7	137.0						

us.	# *	-	2	Ave	1	2	Ave	1	7	Ave	1	2	Ave	-	2	Ave	1	2	Ave	1	2	Ave
Cycle Type: Scan C nditions	Sample ID		B 6			၁၈			06			ш			H O		9 B Ac	? .	Received	9 F As	•	Received

RXT-2 Extrusion

Sample I.D.	8 6	ဝွ	G	Э6	9F
POLYMER TYPE MBM/technic & lactam blends	Blend #9	Blend #9	Blend #8	Blend #9	Blend #9
	- - - -	<i>(*</i> U .			3/11/2008
water on feeding zone	CO	6	CO	G	uo
zone 1 Temp. (deg c)	220	230	240	250	260
zone 2 Temp. (deg c)	220	230	240	250	260
zone 3 Temp. (deg c)	220	230	240	250	260
zone 4 Temp. (deg c)	220	230	240	250	260
zone 5 Temp. (deg c)	520	230	240	250	260
zone 6 Temp. (deg c)	220	230	240	250	260
zone 7 Temp. (deg c)	220	230	240	250	260
8 Connecting Plate Temp. (deg. C)	220	230	240	250	260
9 Block Temp. (deg.C)	220	230	240	250	260
10 Spin Pump Temp. (deg.C)	220	230	240	250	260
11 Top Cap (deg.C)	220	230	240	250	260
12 Spin Pack Temp. (deg.C)	220	230	240	250	260
Barrel Melt Temp. (deg. c)	225	235	245	255	265
Melt Pump Inlet Pressure (psi)					
Melt Pump Outlet Pressure (psi)					
Extruder (rpm)	200	200	200	200	200
Monomer Exhaust inches water					
Spinneret: no. of holes / Shape	6R	6 R		6R	eR S
Spinneret: capilary diameter & depth	.01778x.061	.01778x.061	061	.01778x.061	.01778x.061
Metering pump size (cc/rev)	1.16	1.16		1.16	1.16
Metering pump (rpm)	7.5	7.5		7.5	7.5
Thruput (lbs/hr)	1.13	1.13	1.13	1.13	1.13
Filter type	STD SCREEN	STD SCREEN	STD SCREEN	STD SCREEN	STD SCREEN
Quench air Flow rate (CF/M)	7.1	7.1	7.1	7.1	7.1
Qench air Temp. (deg. c)	20.1	20.1	20.1	20.1	20.1
Quench air Humidity %	54.5	54.5	54.5	54.5	54.5
% Torque	21	21	21	21	21
Nitrogen in Hoper	က	က	က	က	က
Need: polymer chips moisture	8				

RXT-1 Take-Up

Sample I.D.			98	၁	Q6	3 E	3 6
	Nylon Blend	pue	[.] ຫ	თ	თ	თ	თ
SAMPLE STAKT TIME SAMPLE FINISH TIME Run time (min) Finish type Kiss r II (rpm)			5-10 min F-137-10 3.7	5-10 min 5-10 min 5-10 min F-137-10 F-137-10 F-137-10 3.7 3.7 3.7	5-10 min F-137-10 3.7	5-10 min F-137-10 3.7	5-10 min F-137-10 3.7
Godets: SMALL Roll #1 SPEED (m/min) SMALL Roll #2 SPEED (m/min)	nin (nin	RXT-2	4090	4090	4090	4090	4090
LARGE Roll #3 SPEED (m/min) LARGE Roll #4 SPEED (m/min.) Entangling	min) n.)	RXT-1	4090	4090	4090	4090	4090
jet type air t jet (psi) Winder gr ve roll: Speed (m/min.) Winder drive roll: Speed (m/min. Undrawn Denier	nin.) iin.		4499 4090 20.0	4499 4090 20.0	4499 4090 20.0	4499 4090 20.0	4499 4090 20.0

st Heat Cycle				
	20) ploH	(min):	na
	10000	Melting 1st Tm	Peaks	۸H۴
	(S)	(C)	(C)	(J/g)
	177.4	184.6	212.6	53.0
	177.6	184.7	213.1	55.0
	177.5	184.7		
	178.3	185.6	214.9	
	177.7	185.4		
	178.0	185.5		
	178.2	185.7		
	178.2	185.7	215.7	
	178.2	185.7	215.6	
	173.7	184.6		
	175.5	185.0	214.5	53.1
	174.6	184.8		56.5
	175.5	183.5		99
	174.2	182.8	,	
	174.9	183.2		
	176.9	185.1		55.6
	177.0	185.2	213.9	
	177.0	185.2		

U.S	Run #	1 2 Ave	1 2 Ave	1 2 Ave	1 2 Ave	1 2 Ave	1 2 Ave	1 2 Ave	1 2 Ave	1 2 Ave	2 Ave
Cycle Type: Scan Conditio	Sample ID	1A	18	1C	2	ဗ	4				

RXT-2 Extrusion

	RXT.	RXT-1 Take-Up	ke-Up		
Sample I.D.	-	8	m	4	ហ
POLYMER TYPE Nylon Blend	-	7	ო	4	2
SAMPLE START TIME SAMPLE FINISH TIME			٠		
Run time (min) Finish tvpe	5-10 min F-137-10	5-10 min 5-10 min 5-10 min 5-10 min 5-10 min F-137-10 F-137-10 F-137-10 F-137-10 F-137-10	5-10 min F-137-10	5-10 min F-137-10	5-10 min F-137-10
Kiss r II (rpm)	3.7	3.7	3.7	3.7	3.7
G dets: SMALL Roll #1 SPEED (m/min) RXT-2 SMALL Roll #2 SPEED (m/min)	4090	4090	4090	4090	4090
LARGE Roll #3 SPEED (m/min) LARGE Roll # 4 SPEED (m/min.) RXT-1	4090	4090	4090	4090	4090
Entangling jet type					
winder grove roll: Speed (m/min.) Winder drive roll: Speed (m/min.	4499 4090	4499 4090	4499 4090	4499	4499
Undrawn Denier	20.0	20.0	20.0	20.0	20.0

, free fall FAV (after each run set) Need: undrawn yarn Denier, instron submit free fall and polymer for FAV Monomer Exhaust inches water

Cvcle Type:				
	18	<i>:</i>	:	•
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Sample ID	 			
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#3	2			
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na		ΔHf	(J/g)	59.7	60.2	60.0	61.8			62.9	66.3	64.6	9.79	68.5		61.5	61.1	61.3		49.9	50.8							
(min):	Peaks	2nd Tm	(၁)	216.3	216.0	216.2		216.5		218.1	218.1	218.1	219.7		219.5	218.0	218.3	218.2	2	172.3	172.2							
) ploH	Melting	1st Tm	(၁)	190.9	190.5	190.7	193.1	192.8	193.0	199.5	199.0	199.3				199.5	200.0	199.8						,				
20		Onset	(၁)	179.4	179.3	179.4	180.6	181.1	180.9	185.1	184.1	184.6	201.9	202.0	202.0	185.8		•	170.5	170.5	170.5		 					